

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021185**Date Inspected:** 18-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhu Zhong Hai**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Ramesh Gade, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

OBG Segment 9BW-FL3

Flux Core Arc Welding (FCAW) in the 3G position of 9BW-FL3 Half diaphragm web to web weld. Weld # SSD25-PP075-48. The welder is identified as 207465. ZPMC Quality Control (QC) is identified as Xu Jin Long. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-B-U2-F. See attached photograph Pic_001.

OBG Segment 9BW-9CW

Shielded Metal Arc Welding (SMAW) in the 4G position of 9BW-9CW Counterweight side DP to EP hold back weld joint. Weld # 9CW-CA061-002. The welder is identified as 045196. ZPMC Quality Control (QC) is identified as Wang Zhu. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-U4b-FCM-1.

OBG Segment 9CE-9DE

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During in process visual inspection this QA Inspector observed ZPMC NDT personnel performing Ultrasonic Testing (UT) of 9CE-9DE DP to DP splice weld. See attached photograph Pic_002.

OBG Segment 9BW-9CW

Flux Core Arc Welding (FCAW) in the 3G position of 9BW-9CW counterweight side SP to SP weld. Weld # OBW9B-007. The welder is identified as 069683. ZPMC Quality Control (QC) is identified as Wang Zhu. The welding variables recorded by QC appeared to comply with WPS-B-T-2233T-1.

OBG Segment 9CE-9DE

Flux Core Arc Welding (FCAW) in the 3G position of 9CE-9DE Bike Path side 'T' rib, weld # SP374-001-44. The welder is identified as 067942. ZPMC Quality Control (QC) is identified as Liu Huajie. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-T.

OBG Segment 9BW-9CW

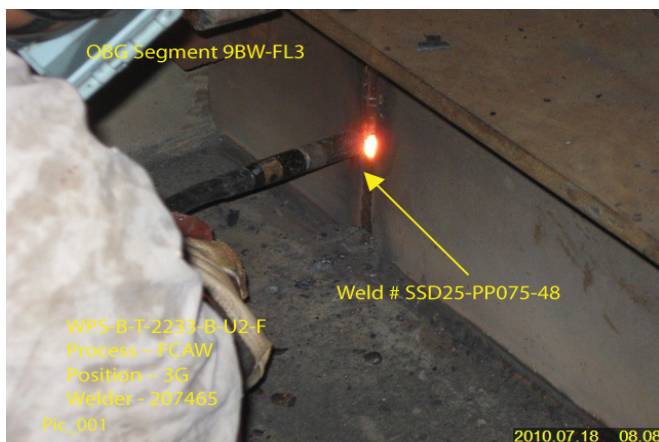
Submerge Arc Welding (SAW) in the 1G position of 9BW-9CW Deck Panel Splice weld, weld # OBW9-008. The welder is identified as 045270 and 045265. ZPMC CWI is identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with WPS-B-T-223(2)1T-2.

OBG Segment 9CE-9DE

Flux Core Arc Welding (FCAW) in the 3G position of 9CE-9DE SP to SP splice weld, weld # OBE9C-004. The welder is identified as 068493. ZPMC Quality Control (QC) is identified as Liu Huajie. The welding variables recorded by QC appeared to comply with WPS-B-T-2233T.

OBG Segment 9BW-9CW

Shielded Metal Arc Welding (SMAW) in the 4G position of 9BW-9CW BP to BP splice weld joint. . The welder is identified as 066326. ZPMC CWI is identified as Zhu Zhong Hai. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1.



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Summary of Conversations:

No relevant conversations reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (+86)15000 42 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Gade,Ramesh	Quality Assurance Inspector
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Reviewed By:	McClendon,Timothy	QA Reviewer
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